

Date: Wednesday, 1/30/2008 7:53:07 AM
User: Kim Johnston

Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PIN ASSEMBLY
Job Number : 37059 -1	
Estimate Number : 11341	
P.O. Number :	Part Number : D3332043
This Issue : 1/30/2008 S.O. No. :	Drawing Number : D3332 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : A1
Previous Run : 35442	Material :
Written By :	Due Date : 2/5/2008 Qty: 5 Um: Each
Checked & Approved By : <u>08 01 30</u>	
Comment : Est: A 05.01.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1018R0500	1018-1025 Steel Bar
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Comment: Qty.: 0.1749 f(s)/Unit Total : 1.7493 f(s)
1018-1025 Steel Bar
Material: AISI 1018-1025 Ø0.500" Round Bar
(M1018-R0.500)
Identify for D3332-7
Batch: M16634

J.F. 08/02/01

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
Machine D3332-7 as per Folio FA493 and Dwg D3332

J.F. 08/02/01

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/02/01

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08/02/01

5.0	M1018R0313	1018-1025 Steel Bar
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Comment: Qty.: 0.2836 f(s)/Unit Total : 2.8361 f(s)
1018-1025 Steel Bar
Material: AISI 1018-1025 Ø0.313" Round Bar
(M1018-R0.313)
Identify as D3332-9
Batch: M17270

M1010R03125 mini 2008/12/19

J.F. 08/02/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3332-CH3 PAR #: N/A Fault Category: Prod/Machined PMS NCR: Yes No DQA: D Date: 08/02/22
 QA: N/C Closed: H Date: 08/02/22

NCR: <u>37059</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-02-01</u>	<u>2.0</u>	<u>1 part is 0.003" under tolerance. Dim is 0.476" RC Operator error</u>	<u>[Signature]</u> <u>08/02/22</u>	<u>Acceptable.</u>	<u>N/A</u>	<u>[Signature]</u> <u>08-02-01</u>	<u>[Signature]</u> <u>08/02/22</u>	<u>[Signature]</u> <u>08-02-01</u>

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:53:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 37059

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Fabricate D3332-9 as per Dwg D3332

JS

08/02/14

(5x)

7.0

D33321

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
Handle Assembly
Pick:

Qty Part Number Description Batch

1 D3332-1 Handle

A/R N/A

Steel Rod

Identify as D3332-043

B35935 — 5x
6/105138

JS 08/02/14 (5x)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble and Weld using D3332-041T1 as per Dwg D3332

JS

08/02/14

(5x)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS

08/02/14

(5x)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD

08-02-14

(5)

11.0

POWDER COATING

POWDER COATING



M18052



(5x)

Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
Cover thread only for D3332-9 prior to painting

M-J

08/02/15

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

JS

08-02-15

(5x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:53:07 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 37059

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 55 498

AS of 12/19 (XS)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS of 12/22 (5)

Job Completion



mini 2008/2/19 (5)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

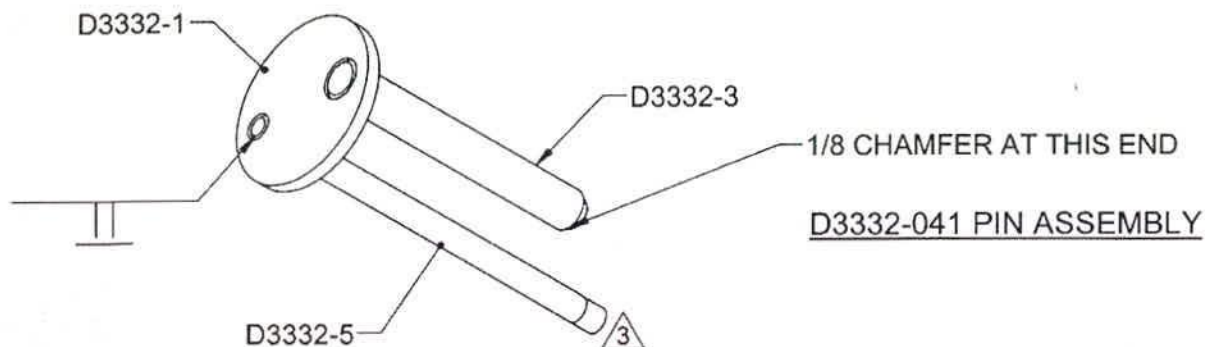
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

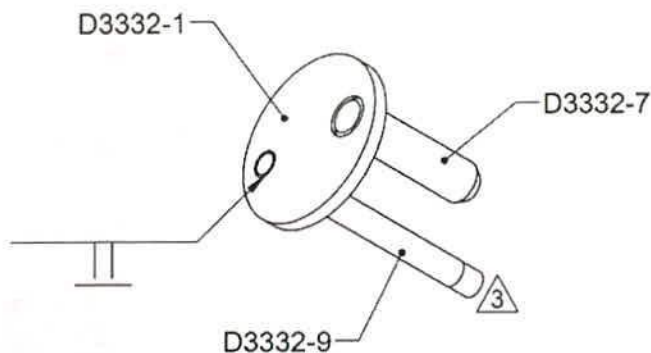
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 1 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE ± 0.000 -0.005	



D3332-041 PIN ASSEMBLY

RELEASED
[Signature]
05/02/09



D3332-043 PIN ASSEMBLY

NOTES:

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

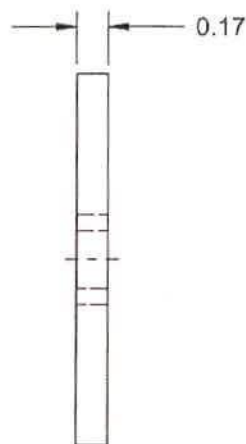
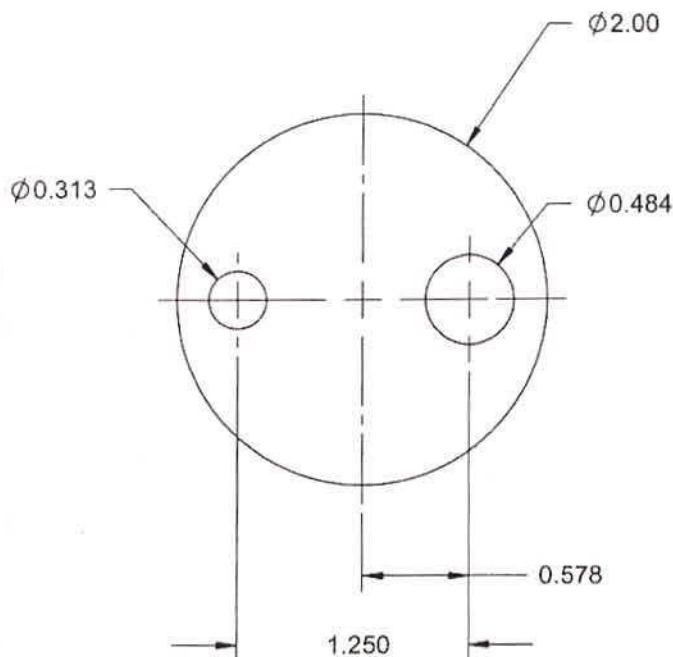
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



RELEASED
[Signature]
05/04/09

D3332-1 HANDLE

NOTES:

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

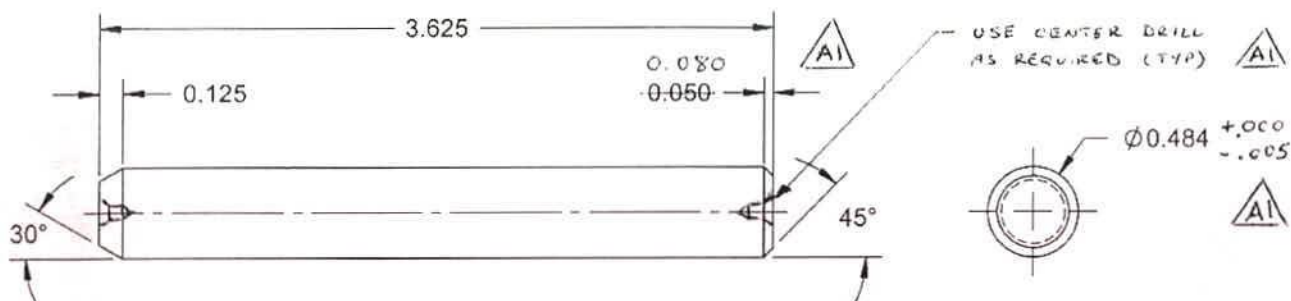
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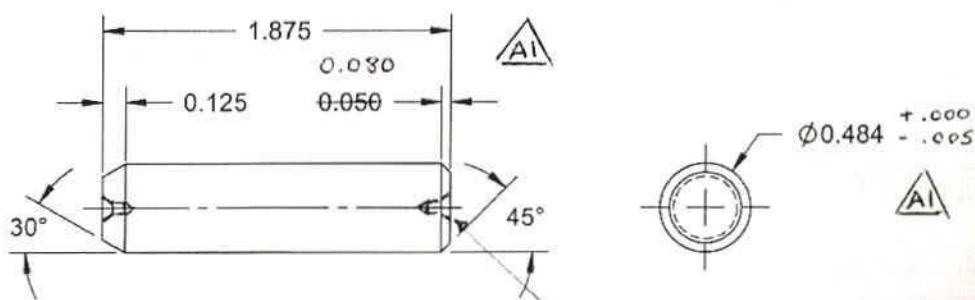
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1

3332-3 PIN

RELEASED
[Signature]
05/02/09

3332-7 PIN

USE CENTER DRILL
AS REQUIRED (TYP)

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

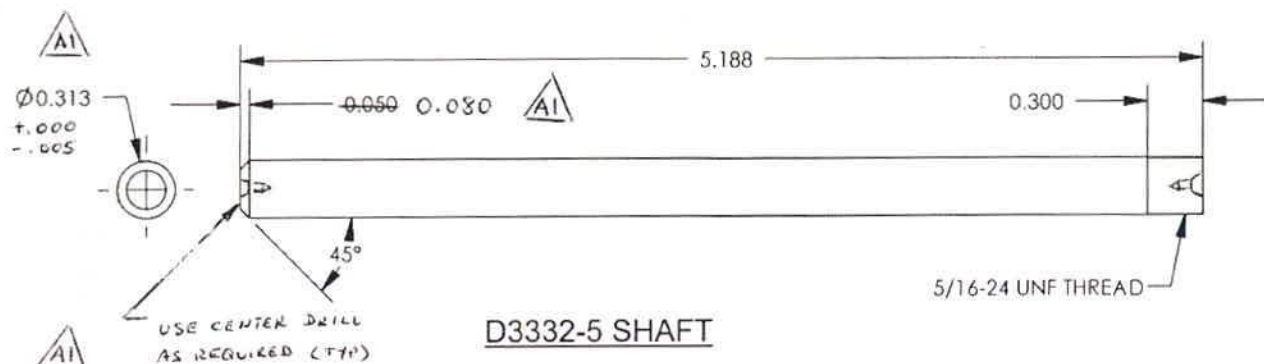
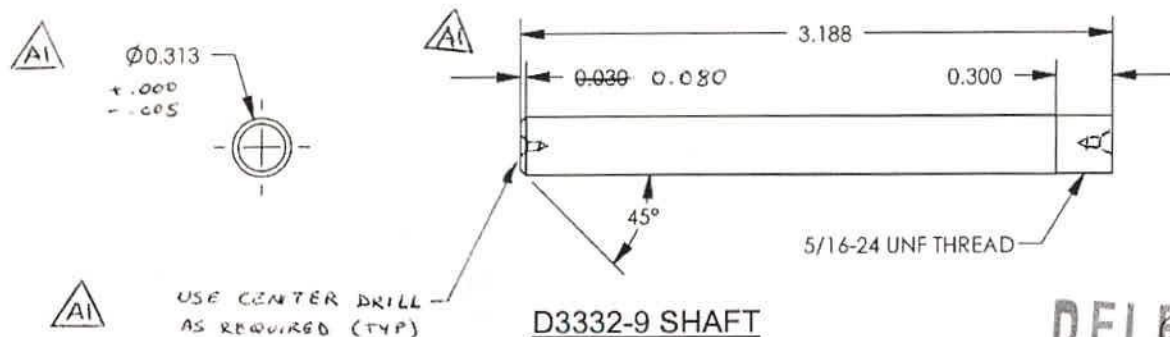
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1

**D3332-5 SHAFT****D3332-9 SHAFT****NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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